





Work Order ID 68161

Thursday, April 07, 2011 11:11:50 AM

Page 1

Item ID:	D4314-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Shim					
Start Date:	4/7/2011	Start Qty: 8.00		Cust Item ID:		
Required Date:	4/14/2011	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date: 11-04-17	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4314	A								

100  FLOW WATER JET 0.00 NOT NOT PULLED

Waterjet **Memo** 0.00 B11-4-7

FLOW CNC Waterjet 1-Cut as per Dwg D4314
 6061.188 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary (10)

110  QC2- Inspect parts off machine FAI/FAIB 0.00 B11-4-7

QC **Memo** 0.00

Quality Control

120  QC8- Inspect parts - second check 0.00 B11-4-7

QC **Memo** 0.00 (10)

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[REDACTED]

Thursday, April 07, 2011 11:11:50 AM

Accept

Setup Start

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Stop

Abstract

Cust Item ID:

Start Date: 4/7/2011 **Start Qty:** 8.00

Required Date: 4/14/2011 Req'd Qty: 8.00

Customer:

Reference:

Run Start

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[illegible]

Small Fab

0.00

Small Fab

Memo

COUNTER SINK AS PER DWG

Small Fab

$\Rightarrow m = 1$ 11/04/11

10X

0.00

[illegible]

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

Subtotal

HO

0.00

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

x10 0 92 4/02/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68161

Thursday, April 07, 2011 11:11:50 AM



Page 3

Item ID: D4314-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 4/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <i>B9E</i>	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*10 BL 11-4-12**11/4/12**11/4/14**11-04-13*
(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 07, 2011 11:12:00 AM

Work Order ID: 68161

Parent Item: D4314-3

Parent Item Name: Shim



Start Date: 4/7/2011

Required Date: 4/14/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188 		Purchased	No			100	sf	32.0000	0.0194	0.163368	15		
6061-T6 .188 Sheet										B11-4-7			

Location

Loc Qty

Loc Code

MAT021

32

116604

32

112999

(10)

~~6861~~ 187 x 4

M6061T6B.187x4-00

This
Batch
only 4/11/04/07.

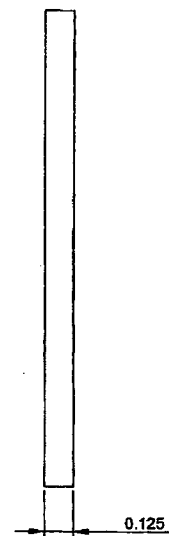
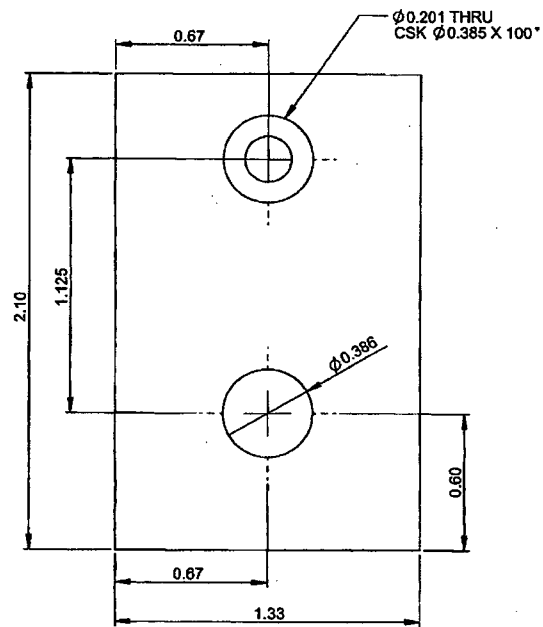
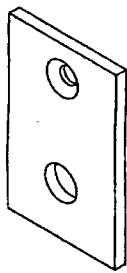
W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68161
PL 11-09-7

D4314-1 SHIM

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

RELEASED
2011-02-01
MB

A NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4314	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE SHIM	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
DATE	11.01.13	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

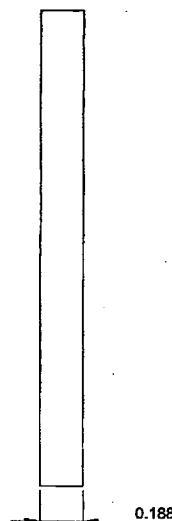
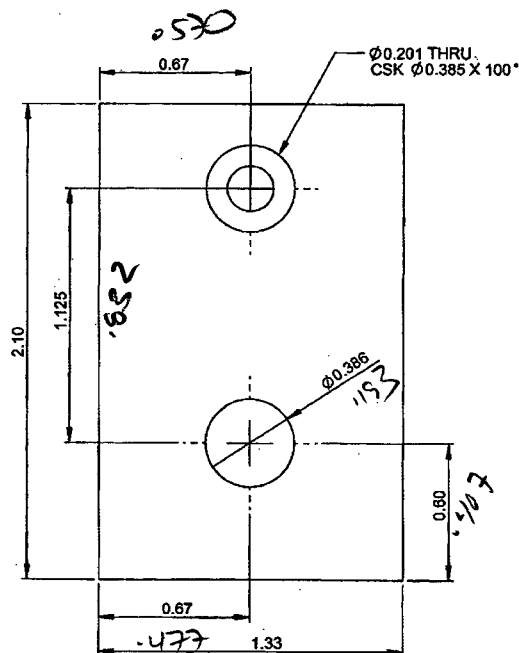
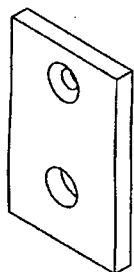
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



u/b 68161

D4314-3 SHIM

RELEASED
2011-02-01
MP

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	MP	D4314	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SHIM	NTS
DATE	11.01.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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